

Date: Monday, 6/12/2006 3:37:07 PM
 User: Ken Johnson

Process Sheet

SPC1A

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOOR PROTECTOR FWD RH
 Job Number : 27509
 Estimate Number : 11234
 P.O. Number : *NIA* Part Number : D32812
 This Issue : 6/12/2006 S.O. No. : *NIA* Drawing Number : D3281 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *NIA* Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 26354 Material : *NIA*
 Written By : *SEE COMMENT BELOW* Due Date : 6/30/2006 Qty: 20 Um: Each
 Checked & Approved By : *06/06/13*
 Comment : Est Rev: A 04.07.01 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *1493* *C. Loe115/06 (20)*
 Description: Floor Protector Fwd, RH
 Possible Supplier: Delastek
 Certificate of Conformity is required

2.0 D32812P Floor Protector, Fwd RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Floor Protector Fwd, RH

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure certificate of conformity is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: *—*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/07/25

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:37:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR FWD RH

Job Number: 27509

Part Number: D32812

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06.07.19

Job Completion



u 06.07.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

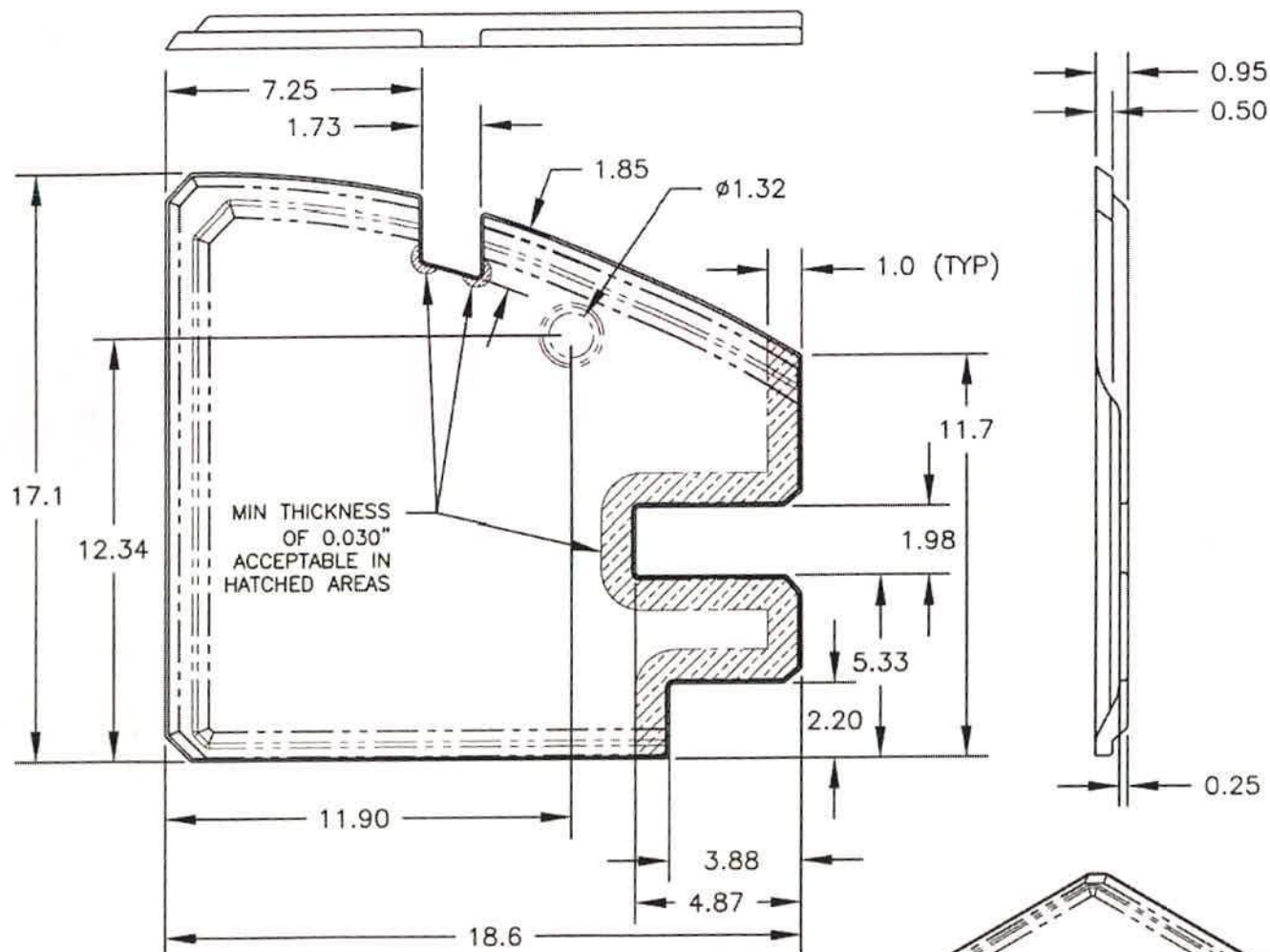
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

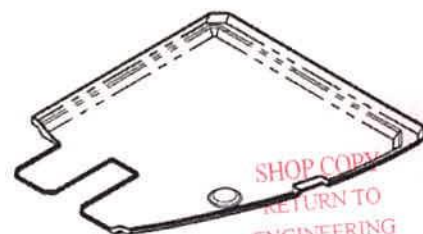
QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	

**RELEASED**
05.12.01**D3281-1 FLOOR PROTECTOR, FWD LH**

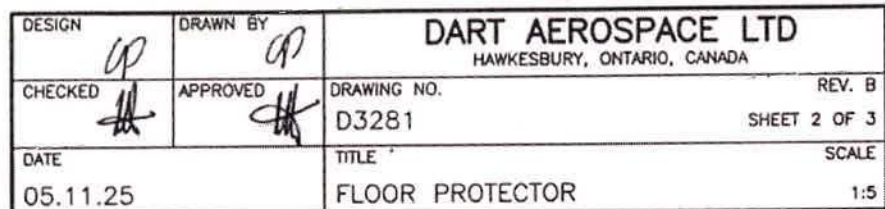
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN



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RELEASED
05.12.01

1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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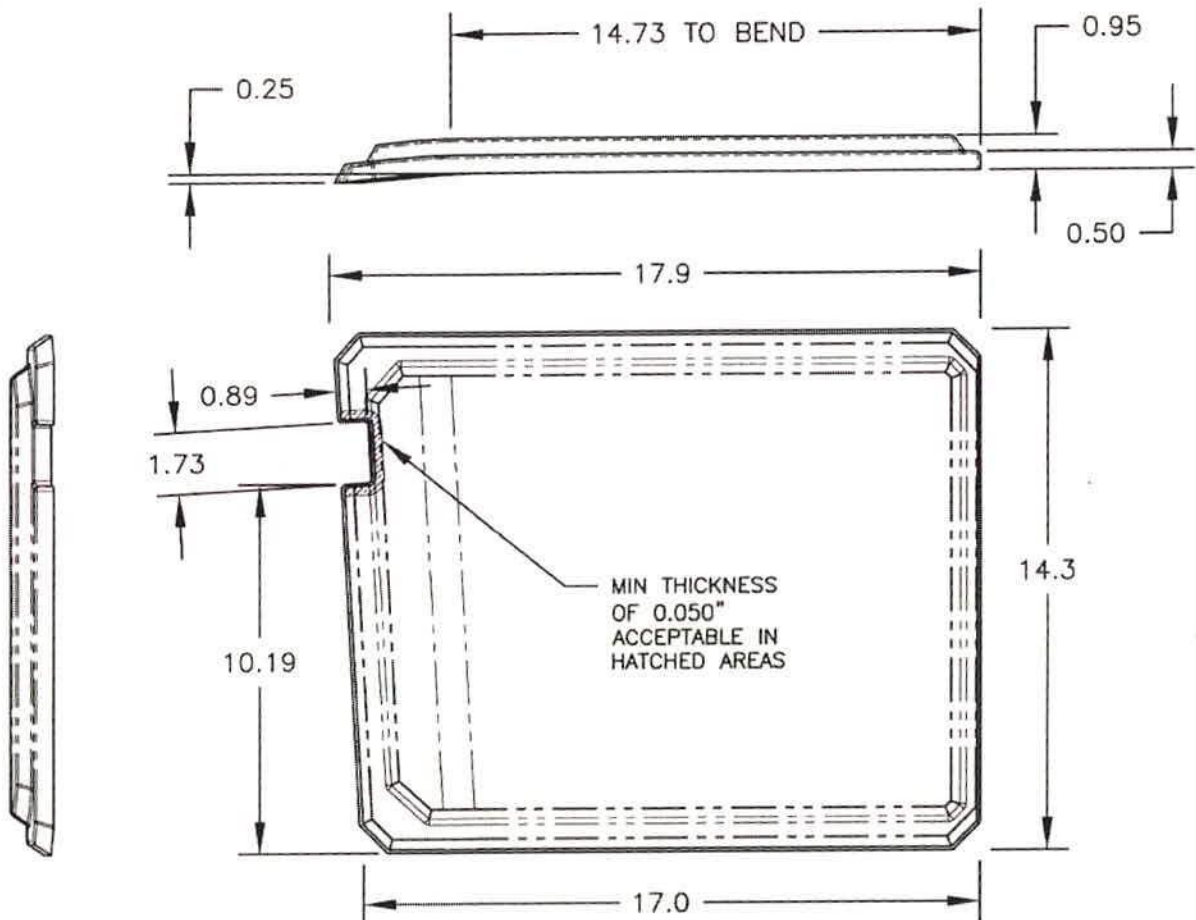
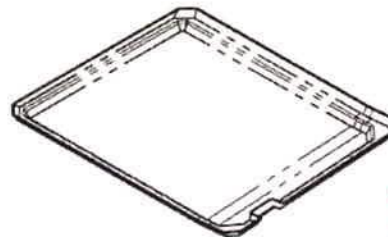
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**
05.12.01. *[Signature]*

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	10766
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
14/07/06	15/06/06	4716	C. Lavoie		PO00001493		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
20	2	18	DKC134-0045	Floor Protect Part 2 N° D3281-2 (F6006) Selon dessin D3281 Rev.: B JOB: 36893 QTE: 18 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357

Date: Jeudi, 2006-06-22 10:51:18
Utilisateur: Marc Dubé

Feuille de Procédé

Client :	DART	Dart Aerospace Ltd.	Nom Dessin :	FLOOR PROTECTOR	
Numéro Job :	36893		Numéro Article :	DKC134-0045	
Numéro Soumission :	2384		Numéro Dessin :	D3281	
Numéro B.A. :			Projet Numéro :	DKC134	
Cette fois :	2006-06-22	No. B.V. :	Révision dessin :	B	
Prsht Rev. :	NC		Matériel :	F6006	
Prem. fois :	- -	Type :	Date Dûe :	2006-06-29	Qté: 20 UdM: UNITE
Job précédente :	34174				
Écrit par :					
Vérifié & Approuvé par :					
Commentaires :	N° de pièce: D3281-2				

Process Sheet Rév.: 00 Création du premier

Produit additionnel

Numéro Job:



Séq.:

Machine ou Opération:

Description:

1.0 APL0016

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentair Qty.: 0.167 UNI

Lexan F6006 Noir

APL0016



1-53271

N° de Lot:

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

2.0 SÉCHAGE/ ANEAL

Bon achat: 5327
SÉCHAGE / ANEALING

Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run: 0.6667Hrs

SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuisson: 5140

3.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run: 60.0000Hrs

TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: de Date: 5-7-06 Sceau: Quantité: 10 Date: 13.07.06 Sceau: E.B.

Feuille de Procédé

# Séq.:	Machine ou Opération:	Description :
4.0	THERMOFORMAGE2	THERMOFORMAGE DES PIECE DART
<p>Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs THERMOFORMAGE DES PIECES</p> <p>Faire le thermoformage du " Floor Protector " N° D3281-2 à l'aide du moule N° D3281-2T1 sur le thermoformeur 4' x 8'.</p> <p>Autocontrôle du lot de pièce thermoformées.</p> <p>Quantité: <u>20</u> Date: <u>7-7-06</u> Sceau: <u>DELASTEK COMPOSITES 69</u></p> <p>Quantité: <u>10</u> Date: <u>13.07.06</u> Sceau: <u>E.B.</u></p> <p>F.O: 4 juillet 06 F.O: 12-07-06</p>		
5.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
<p>Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs TRIMAGE PLASTIQUE DART</p> <p>① Faire le trimage du " Floor Protector " N° D3281-2 à l'aide du gabarit de trimage N° D3281-2T2.</p> <p>② Rebavurage des pièces.</p> <p>Autocontrôle de la pièce trimées.</p> <p>① Quantité: <u>20</u> Date: <u>7-7-06</u> Sceau: <u>DELASTEK COMPOSITES 69</u></p> <p>② Quantité: <u>20</u> Date: <u>11-07-06</u> Sceau: <u>DELASTEK COMPOSITES 50</u></p> <p>10x 13.07.06 E.B. F.O: 6 juillet 06 8-13-07-06</p>		
6.0	INSPECTION 3	INSPECTION PIÈCE DART
<p>Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs INSPECTION PIÈCE DART</p> <p>Faire l'inspection finale des pièces selon le dessin.</p> <p>Quantité: <u>28</u> Date: <u>13-07-06</u> Sceau: <u>DELASTEK COMPOSITES 69</u></p> <p>2 rejets à l'inspection Voir emballage pour autre inspection</p>		
7.0	IDENTIFICATION4	IDENTIFICATION PIÈCES DART
<p>Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs IDENTIFICATION PIÈCES DART</p> <p>Faire l'identification des pièces à l'aide des informations suivantes:</p>		

Feuille de Procédé

* Client: DART Dart Aerospace Ltd.
Numéro Job: 06693

Nom Dessin: FLOOR PROTECTOR
Numéro Article: DKC134-0045

Numéro Job:



Séq.: Machine ou Opération: Description :

N° de pièce: D3281-2

10x 13.07.06 E.B.

N° de Job: _____

Date de fabrication: _____

Sceau d'inspection:

Quantité: 15 Date: 11-07-06 Sceau:

5 rejets

Quantité: 8 Date: 13-07-06 Sceau:

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton
identifiée comme suit:

N° de pièce: D3281-2

Date de fabrication: _____

N° de job: _____

Quantité: 10 Date: 11-07-06 Sceau:

10 def E.B.
5 rejets #RNC: C1133

Quantité: 18 Date: 13/7/06 Sceau: